

ABSTRACT OF THE DISCLOSURE

A molded product consisting of a skin layer and a core layer is obtained by injecting a skin layer resin and a core layer resin from a skin injection unit 13 and a core injection unit 12 into metal molds 8, 9, respectively. The skin layer resin injection pressure by the skin injection unit 13 and the core layer resin injection pressure by the core injection unit 12 are controlled in such a manner that a volumetrically reduced quantity at the time of cooling and solidifying the skin layer resin is compensated so as not to generate defects such as hollows and the like in the molded product. It is characterized in that the state the core dwelling pressure is higher than the skin dwelling pressure over a predetermined length of time.